

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008227**Date Inspected:** 28-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, Liu Zhangan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress

OBG Segment 3AE

FCAW welding process of weld joint 003 located on PCMK SSD17A-PP21. Welders are identified as 044795, 051356 ZPMC QC is identified as Liu Wang Ning. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair-2.

Green Tag

This QA Inspector was issued green tags No 177 for OBG components after completing the final tension verification requirements. The components detail as 'U' Rib to 'U' Rib (Except big splice location No.7, 23, 32 from north side) of segment 2AE to 2BE at PP 13.5 to 14.

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WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 81A located on PCMK NSTL3-1B/K. Welder is identified as 066730 ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

TRIAL ASSEMBLY YARD

OBG segment 2AE

Visual Inspection

This Quality Assurance (QA) Inspector witnessed final tension verification for Longitudinal Diaphragm splice (4750mm above B.P –North and South side) of segment 2AE at PP 13 to 14. Inspected 10% of installed bolts and found tension verification satisfactory. Bolt sizes used are M24 x 120 RC Lot No. DHGM240024, final Torque required is 553 N-m and M24x75 RC Lot No.DHGM240020, final torque required is 600N-m and M24x100 RC Lot No.DHGM240022, final torque required is 527N-m and M24x90 RC Lot No.DHGM240028, final torque required is 540N-m. Tension verification carried out by Manual Torque wrench with Sr. No. X02-667.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
